



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

C2-11-1
Job Sheet 183516



Part No: C2-11-1

Job Qty: 4 ea

Part Name: Side Plate, Solenoid



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/19/18

Job Tracking No:

Due Date: 10/12/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG C2-11-1 Rev. 9 IPP Rev. A 18.05.07 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		10/12/18	0.00	0.00	Start Up Machining-1		J.C.L.
100	Bandsaw	4 pcs		10/12/18	0.00	0.67	Bandsaw1		J.C.L.
120	Mori Seiki	4 pcs		10/12/18	2.00	4.00	MORI NV5000-1		J.C.L. 18-11-18
130	QC	4 pcs		10/12/18	0.00	0.00	QC2 Machining-5		J.C.L. 18-11-18
140	QC	4 pcs		10/12/18	0.00	0.00	QC8 Machining-5		H.19-06-21
150	Outsource Anodize	4 pcs Black		10/12/18	0.00	0.00	Outsource4 GRO002		2019-06-27
160	Packaging	4 pcs		10/12/18	0.00	0.00	Packaging2		DP JUL 03 2019
170	QC	4 pcs		10/12/18	0.00	0.00	QC6		51
180	Packaging	4 pcs		10/12/18	0.00	0.00	Packaging3-2		J-80 JUL 05 2019
190	QC21-SA	4 Ea		10/12/18	0.00	0.00	QC21		21

Part Op 100 - 1- Cut 6.50" long

Descriptions: 120 - 1-Machine as per folio FC418 FOLIO REV: AA DWG REV: 9 2-Machine Engrave S/N SEE PEC FOR PROGRAMMING 3-Deburr

150 - Issue P/O to Groupe Altech : -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS

2, Water sealant -Certificate of Conformity is required

160 - Receive

180 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.750X05.000	6061T6 Bar 0.750 X 5.000	2.1640 ft (.541 ea)	90-Start up Operation	5072716

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B0.750X05.000	2	12	0

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Specifications

could not be found.



Container No: S128653



Part: C2-11-1

Job No: 183516

Serial No/Batch: S128653

Revision: 9

Inspector:

Exp Date:

Instructions:

Date: 11/16/18

Plex 10/11/18 1:29 PM Dart.lajeunesse.marie

GA 191

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

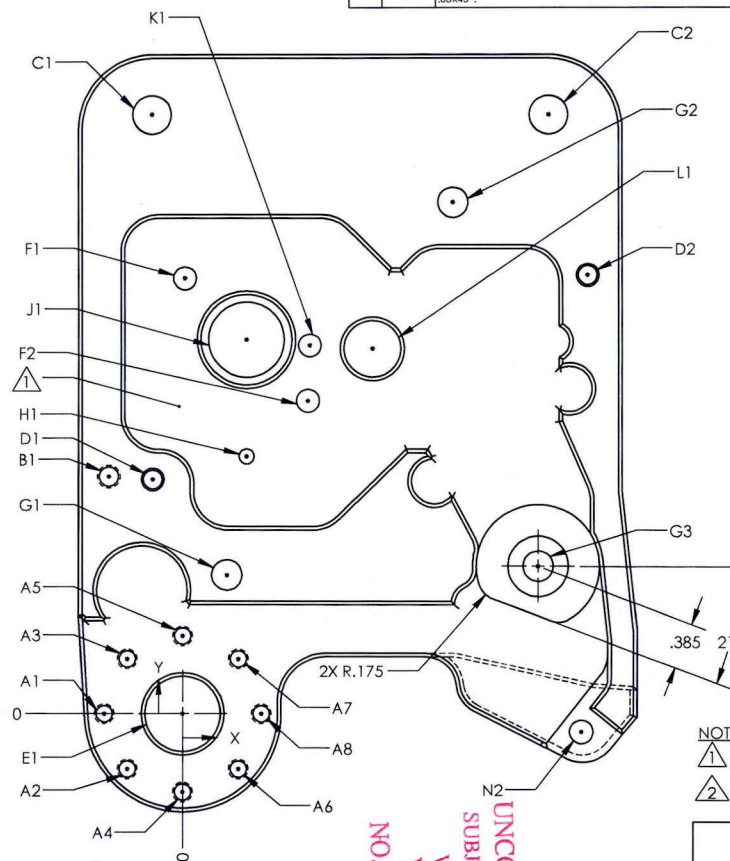
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

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REVISIONS						
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED	
8	14-0104	CHD TITLE BLOCK WAS RED BARN IS DART. ADDED MACHINE ENGRAVE NOTE, CHD DIMENSION TOLERANCES ON NON-CRITICAL DIMENSIONS. SHEET 2 CHD DIMENSION TOLERANCES ON NON-CRITICAL DIMENSIONS.	8/7/2014	DPD	RW	
9	16-0116	UPDATED TO NEW STANDARD, CHD DIM WAS $\phi .191$ IS $\phi .195 +.003 -.000$, ADDED HOLE DEPTH NOTE, SHEET 2 CHD DIM WAS (.625) IS $.625 +.000 -.010$, WAS $.06 \times 48^\circ$ IS $.03 \times 45^\circ$, ADDED DIM $.03 \times 45^\circ$.	8/15/2016	DEW	JAG	

TAG	X LOC	Y LOC	SIZE
A1	-.650	-.000	8-32 UNC THRU ALL
A2	-.460	-.460	
A3	-.460	.460	
A4	.000	-.650	
A5	.000	.650	
A6	.460	-.460	
A7	.460	.460	
A8	.650	.000	
B1	-.613	1.972	10-32 UNF THRU ALL
C1	-.253	4.982	$\phi .320$ THRU ALL
C2	3.027	4.982	$\phi .156$ THRU ALL $\square \phi .1875^{+.0005}_{-.0000} \nabla .550$
D1	-.249	1.948	
D2	3.350	3.650	
E1	.000	.000	
F1	.019	3.620	$\phi .189$ THRU ALL
F2	1.035	2.604	$\phi .250^{+.005}_{-.000}$ THRU ALL $\phi .6258$ THRU ALL $\checkmark \phi .685 \times 90^\circ$, NEAR SIDE
G1	.364	1.155	
G2	2.235	4.252	
G3	2.939	1.232	
H1	.527	2.140	$\phi .125 \nabla .200$
J1	.527	3.112	$\phi .625$ THRU ALL $\square \phi .7518^{+.0000}_{-.0005} \nabla .266^{+.003}_{-.000}$ $\checkmark \phi .812 \times 90^\circ$, NEAR SIDE
K1	1.051	3.065	$\phi .1874$ THRU ALL
L1	1.568	3.038	$\phi .4691$ THRU ALL $\phi .4684 \nabla .265^{+.003}_{-.000}$ $\checkmark \phi .530 \times 90^\circ$, NEAR SIDE
N2	3.299	-.147	$\phi .195^{+.003}_{-.000}$ THRU ALL



NOTE:
 1 MACHINE ENGRAVE BATCH NUMBER.
 2 ALL HOLE DEPTHS CALLED FROM THIS SURFACE.

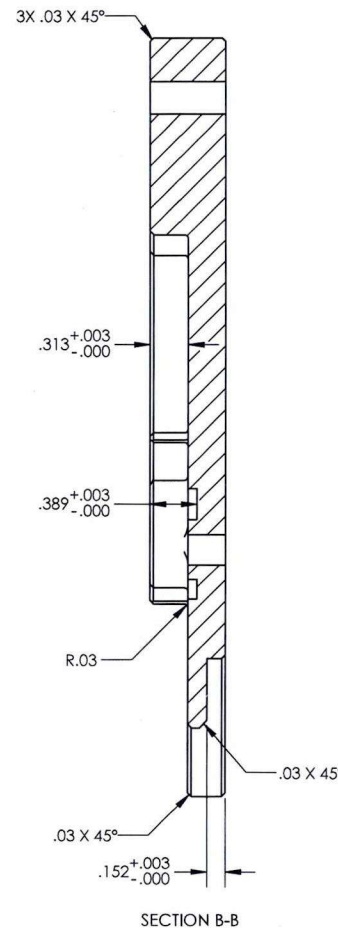
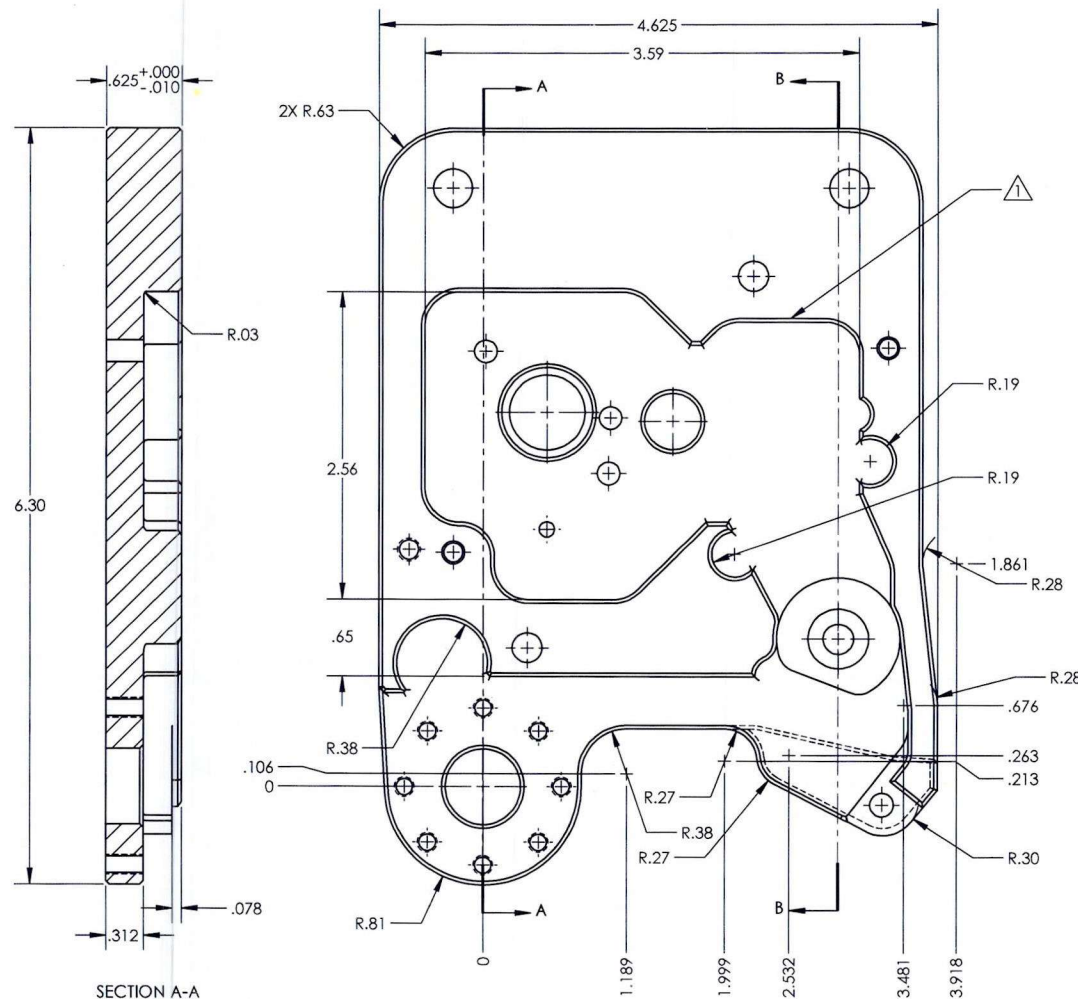
DART AEROSPACE	
TITLE SIDE PLATE SOLENOID	
DWG NO. C2-11-1	REV 9
MATL 6061	UNLESS OTHERWISE SPECIFIED
FINISH BLACK ANODIZE	DIMENSIONS ARE IN INCHES
SPEC MIL-A-8625F, TYPE II, CLASS II	.XXX $\pm .005$ FRACTIONS $\pm .18$
DRAWN BY: CANAM	.XX $\pm .01$ ANGLES $\pm .5^\circ$
CHECKED: DUERFELDT	.X $\pm .1$ SURFACES $\pm .125$
OPPS APPR: ANDERSON	1. BREAK ALL SHARP EDGES
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
SCALE 1:1	ASME Y14.5M-2009
DATE 7/11/2002	USED ON MODEL
SHEET 1 OF 2	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			C2-11-1	1	SIDE PLATE SOLENOID	6061	

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 18-09-19

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REVISIONS					
REV	ECP	DESCRIPTION	DATE	INITIAL	APPROVED
8	14-0104	CHD DIMENSION TOLERANCES ON NON-CRITICAL DIMENSIONS.	8/11/2014	DJN	RW
9	16-0116	SHEET 2 UPDATED TO NEW STANDARD. CHD DIM WAS (.625) IS .625 +.000 -.010, WAS .06 X 48° IS .03 X 45°. ADDED DIM .03X45°.	8/15/2016	DEW	JAG



- NOTES:
- USE CAD DATA FOR POCKET DETAILS.
 - SOME HIDDEN LINES REMOVED FOR CLARITY.

DART AEROSPACE	
TITLE SIDE PLATE SOLENOID	
DWG NO. C2-11-1	REV 9
MAT'L 6061 FINISH BLACK ANODIZE SPEC MIL-A-8625F, TYPE II, CLASS II	
DRAWN BY: CANAM CHECKED: DUERFELDT OPFS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES ± 125/ 1. BREAK ALL SHARP EDGES .015 X 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 USED ON MODEL
SCALE 1:1	DATE 7/11/2002

DART AEROSPACE LTD		Work Order: 183516
Description: Side plate solenoid		Part Number: C2-11-1
Inspection Dwg:	Rev: 9	Page 1 of 1

INSPECTION SHEET

	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
	8-32	90-10 30	60	✓		90/10 30	
	10-32	90-10 30	60	✓		90/10 30	
	Ø.320	-.001 +.005	.323	✓		pins	
	Ø.156	-.001 +.004	.157	✓		pins	
	11.1875	-.010 +.0005	.1880	✓		pins	
	∇.550	H/- .005	.550	✓		mc ob	
→	Ø.6254/6258		.6255	✓		pins	
	∇ Ø.685 90°	H/- .005	.683	✓		pins	
	Ø.189	-.001 +.005	.193	✓		pins	
	Ø.250	-.000 +.005	.250	✓		pins	
	Ø.125	-.001 +.004	.125	✓		pins	
	∇.200	H/- .005	.201	✓		mc ob	
	Ø.625	-.001 +.005	.626	✓		pins	
→	40.7518	±.000 - .0005	.7515	✓		pins	
	∇.266	-.000 +.003	.269	✓		mc ob	
	∇ Ø.812 90°	H/- .005	.809	✓		pins	
→	Ø.1874/1869		.1870	✓		pins	
→	Ø.4684/4691		.4685	✓		pins	
	∇.265	-.000 +.003	.269	✓		mc ob	
	∇ Ø.530 90°	H/- .005	.526	✓		pins	
	Ø.195	-.000 +.003	.196	✓		pin	
E1	Ø.000	Ø.000					
J1	X.527	H/- .005	.526	✓		dial	
	Y 3.112	H/- .005	3.1124	✓		dial	
L1	X 1.568	H/- .005	1.568	✓		dial	
	Y 2.038	H/- .005	2.0384	✓		dial	
G3	X 2.939	H/- .005	2.938	✓		dial	
	Y 1.232	H/- .005	1.232	✓		dial	
K1	X 1.051	H/- .005	1.051	✓		dial	
	Y 2.065	H/- .005	2.065	✓		dial	
B1	X .613	H/- .005	.613	✓		dial	
	Y 1.972	H/- .005	1.972	✓		dial	

Measured by: PJ	Checked by: [Signature]	QC Inspector:
Date: 18-11-16	Date: 19-06-21	Date:

Engineering Approval: (If necessary)	Date:
--	--------------

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB043867



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043867

PO Date: 6/27/19

Due Date: 7/5/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-06-28

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	183516	C2-11-1	Side Plate, Solenoid -Issue P/O to Groupe Altech -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	7/5/19	8 pcs	0 pcs	8 pcs	\$15.00/pcs	\$120.00
2	196617	RBEL133M- 6201-101-3	Bottom Rail -Issue P/O; -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	7/5/19	3 pcs	0 pcs	3 pcs	\$40.00/pcs	\$120.00

Grand Total: \$240.00



Dart Aerospace Ltd.
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Tel (613) 632-5200

PURCHASE ORDER
POHB043867



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 6/28/19 11:04 AM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(020381-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupaltech.com

Bon de Livraison / Packing Slip

020381- 1

Livré à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.					
03-Jul-2019		SVETLANA DORZHIYEVA				POHB043867				
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)		CATG. U/M	Comm. /Ordered	Exp/ Shipped	Quantités / Quantities Qté NC/ NC Qty		Qté Scrap/	À venir/ Back Order
1	C2-11-1 Rev.	C2-11-1 ANO-BLACK [ANODIZE BLACK] PER IAW MIL-A-8625F TYPE 2, CLASS 2 WATER SEALANT		ANODIZE CH	8	8	0	0	0	
2	RBEL133M-6201-101-3 Rev.	RBEL133M-6201-101-3 ANO-CLEAR [ANODIZE CLEAR] PER IAW MIL-A-8625F TYPE 2, CLASS 1 WATER SEALANT		ANODIZE CH	3	3	0	0	0	

RECEIVED

JUL 03 2019

DART AEROSPACE LTD.

DAS
61
9-88

RECEIVED
JUL 03 2019
DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

2 BOXES

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.